

Work Order ID 88688

88688

Page 1

July-30-12 2:33:26 PM

Item ID: D3650-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Center Panel

Start Date: 7/30/12

Start Qty: 1.00

Cust Item ID:

Required Date: 7/31/12

Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3650

Rev G

100

0.00

100

FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3650

304, 018

Dwg Rev:

Prog Rev: IC custom

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

SCRAP

1 0 Jm 12-7-30

12/07/30

Work Order ID 88688

July-30-12 2:33:26 PM

Item ID: D3650-3
Revision ID:
Item Name: Center Panel
Start Date: 7/30/12 Start Qty: 1.00
Required Date: 7/31/12 Req'd Qty: 1.00
Reference:

Approvals: Process Plan: _____ Date: _____
QC: _____ Date: _____

Sequence ID/ Work Center ID	Operation Description
160	Large Fab
160	Memo
Large Fab	1-trim to fit (D2
Large Fab	2-Weld assemb
	3-grind weld s
170	QC9- Inspect visual per Q
170	Memo
QC	
Quality Control	
180	QC5- Inspect part compl
180	Memo
QC	
Quality Control	

Work Order ID 88688

July-30-12 2:33:26 PM

88688

Page 2

Item ID: D3650-3
Revision ID:
Item Name: Center Panel
Start Date: 7/30/12 Start Qty: 1.00
Required Date: 7/31/12 Req'd Qty: 1.00
Reference:

Accept

N9000040100

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00				2	0		29
Quality Control									
130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00							
Brake NC	1-Form as per Dwg D3650 using DT9426								
	2-bend as per dwg								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

part scanned
8/17/12

22

Picklist Print

July-30-12 2:33:26 PM

Page 1

Work Order ID: 88688

Parent Item: D3650-3

Parent Item Name: Center Panel

Start Date: 7/30/12

Required Date: 7/31/12

Start Qty: 1.00

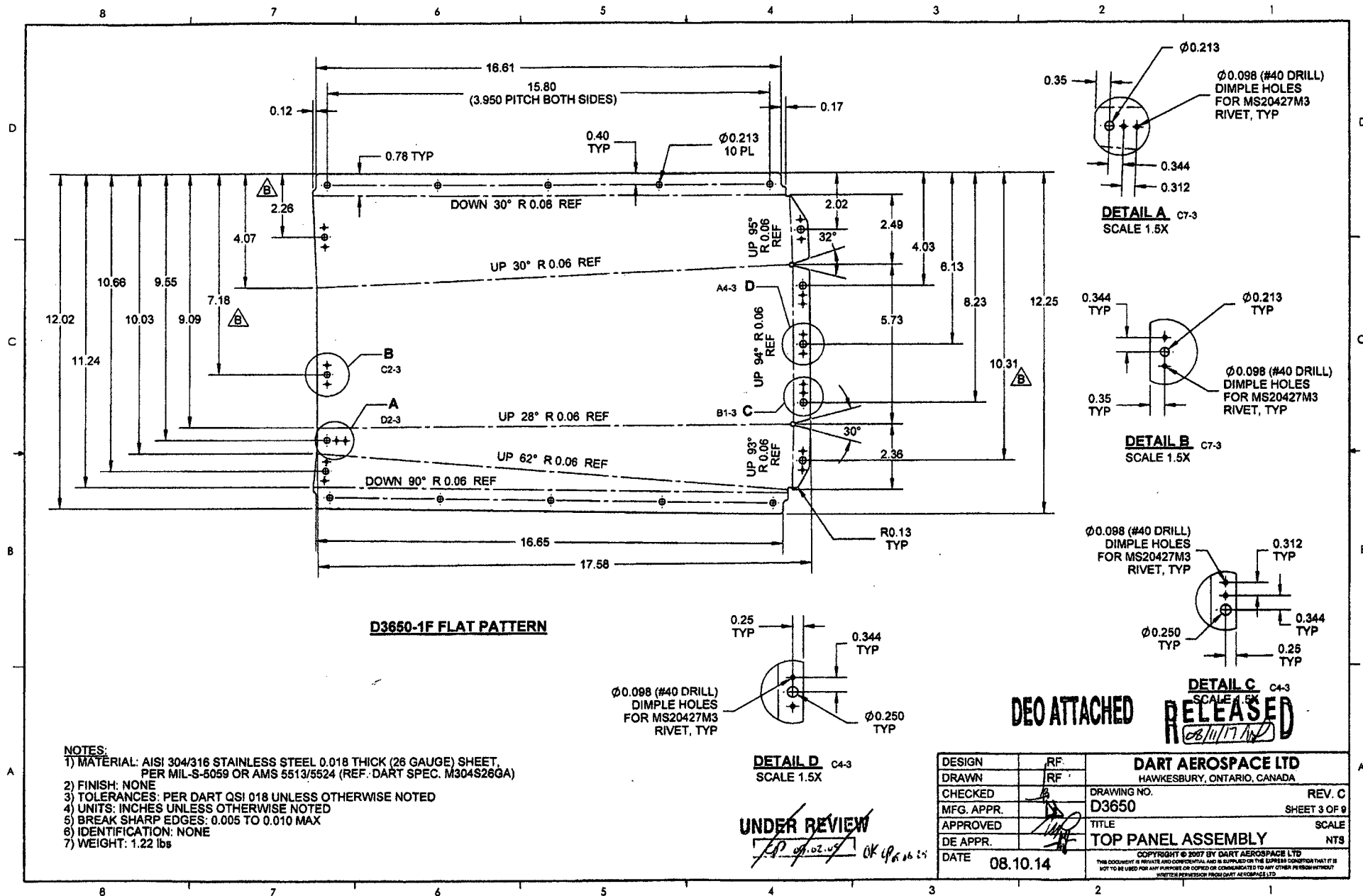
Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
 IPP Rev:B ECN 1113P 08-01-22 DD
 IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3650-11 Filler Plate		Manufactured	No			160	Each	5.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA021		5							
				45721		5							
M304S26GA 304/316 0.018 SHEET		Purchased	No			160	sf	74.2500	1.145	1.2052632			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		74.25							
				117798		74.25							

117798

JM 12-7330



DART AEROSPACE LTD		Work Order: 88688
Description: Center panel		Part Number: D3650-1
Inspection Dwg: D3650 Rev:		Page 1 of 3

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.12	± 0.10	0.122			✓	
16.61	± 0.030	16.65			mt	
15.80	± 0.030	15.81			mt	
0.78 Typ	± 0.010					
0.40 Typ	± 0.010					
0.213	± 0.005-0.001	0.213			✓	
0.17	± 0.004-0.001	0.175			✓	
2.02	± 0.010	2.021			✓	
32°	±					
2.49	± 0.010	2.493			mt	
4.03	± 0.010	4.05			mt	
6.13	± 0.010	6.133			mt	
8.23	± 0.030	8.234			mt	
10.31	± 0.030	10.315			mt	
12.25	± 0.030	12.257			mt	
5.73	± 0.010	5.74			mt	
2.36	± 0.010	2.37			mt	
36°	±					
R0.13 Typ	±					
16.65	± 0.030	16.71			mt	
17.58	± 0.030	17.58			mt	
2.26	± 0.010	2.25			mt	
4.07	± 0.010				mt	

Measured by: SPS	Audited by: ^{DA} 29 289	Preliminary Approval:
Date: 12.7.31	Date: 12/07/31	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

1957

